

Work Order ID **74648-2**



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Tuesday, October 04, 2011 3:21:50 PM

Item ID: **D6101-001**

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Billet

Start Date: 10/4/2011 Start Qty: 80.00

Required Date: 10/10/2011 Req'd Qty: 80.00

split 57



Cust Item ID:

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: *11-10-04* Tooling:

Date:

Stop



QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D6101

Rev B

0.00

100



Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: *15091*

a) Description: Aluminum Billet

b) 6.00" x 6.250" x 2.00" thick

c) Tolerance on length are +0.030"/-0.000" A+/-0.008"

d) Grain direction along 6.00" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

0.00

11-10-4 80

110



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

Ensure material certification is attached

0.00

11/10/27

Work Order ID 74648

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Item ID: D6101-001

Accept



Setup Start



Revision ID:

Item Name: Saddle Billet

Stop



Start Date: 10/4/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 10/10/2011 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

mf 11/10/26

59 0

Quality Control

Ensure Material certification comply to Dwg D

130

Identify as per dwg & Stock Location: *14TY0*

0.00



Packaging

Memo

0.00

mf 11/10/26

59 0

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/10/27
mf
21-10-20

Quality Control

Picklist Print

Page 1

Tuesday, October 04, 2011 3:21:58 PM

Work Order ID: 74648



Parent Item: D6101-001



Parent Item Name: Saddle Billet



Start Date: 10/4/2011

Required Date: 10/10/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP B: 01.05.04 New Issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001P  7075-T7351 2X6X6.25		Purchased	No			110	Each	0.0000	1 	80			

Full 427

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP

Page 1 of 1

Shipment No:1034473

Ship From: A. M. Castle & Co. (Canada) Inc. MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 24-OCT-2011	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 1034473-2	

Shipment Details	Final Destination Branch - MON
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Order No 1765972	Line No 1	Item No 752237.MO	Description 2.0000.PL.7075.T7351.ALUMINUM.USI.48.5000.144.5000 CUT 2SIDED TO 6.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) X 6 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) - ALUMINUM PLATE SAW SPECIFICATIONS: QQ-A-250/12				
Purchase Order No 15091		Part Number YOUR ITEM NUMBER: D6101-001		Ordered Qty 59.00 PCS		Invoice Qty 59 PCS	
Details							
Delivery No. 100322332	Mill	Heat Number 510182A9	Mech Id	PCS 59	Width (IN)	Length (IN)	Shipped Qty(LBS) 456.75

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.	
We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.	
Reviewed by Authorized Castle Metals Representative:	Date: Name:

SHIP TO:

A M CASTLE & CO
3050 SOUTH HYDRAULIC
WICHITA, KS 67216

**KAISER
ALUMINUM**

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

SOLD TO:

AM CASTLE & CO- SOLD TO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

CERTIFIED TEST REPORT

Serial Number
4196201

CUSTOMER PO NUMBER: 55603		WORK PACKAGE:		CUSTOMER PART NUMBER: 6857 AMC A97075-160		SHIP RUN/LOAD: 101815/8		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1099172		LINE ITEM: 3	SHIP DATE: 10-JUN-2010		ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: Sawed Plate	
WEIGHT SHIPPED: 2892 LB		QUANTITY: 2 PCS EST.		B/L NUMBER: 2027686		GAUGE: 2.0000 IN		DIAMETER/WIDTH: 48.500 IN	LENGTH: 144.500 IN

Certified Specifications

AMS 4078/RevG
ASTM B 209/Rev07
BSS 7055/RevA
DPS 4.713/RevAH
MMS 159/RevN

AMS-QQ-A-250/12
ASTM B 594/Rev06
CMMP 025/RevS
GAMPS 9101/RevB
PS 21211/RevK

AMS-STD-2154
BAC 5439/RevH
CSTI 006/RevC
GSS16100/RevG/Amd1

Test Code: 4297

Test Results

Lot: 510182A9 Cast 320 Drop 24 Ingot 4

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	73.8 : 74.3 (509 : 512)	63.2 : 63.6 (436 : 439)	12.4 : 12.8

(ASTM E1004)

(EN 2004-1)

Conductivity %IACS :	40.9 Min	41.0 Max
(MS/M) :	23.7 Min	23.8 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.13	0.22	1.4	0.04	2.5	0.21	5.8	0.03	0.01	0.01	TOT 0.05



KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4196201

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

TEST NOTES

7075-T7351 plate 3.501-4.000" thick, if
ultrasonically inspected, meets requirements of CMMPO25 per
SDR CMMPO25-KaiserT-3. 7075-T7351 plate 4.001-5.000" thick,
if ultrasonically inspected, meets requirements of CMMPO25
per
SDR CMMPO25-KaiserT-2.

Metal represented by this test report was immersion
ultrasonically tested from one side and meets the Class A
and Class B requirements of all specifications referenced
on this test report.

CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE UNITED STATES OF AMERICA OR A QUALIFYING COUNTRY PER DFARS 225.872-11(a), WAS MANUFACTURED IN THE UNITED STATES OF AMERICA, AND MEETS THE REQUIREMENTS OF DFARS 252.225 FOR DOMESTIC CONTENT. THIS MATERIAL HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED.

BILL POYNOR, LABORATORIES SUPERVISOR

Bill Poy

